Work Order ID 101596 May-13-13 1:09:33 PM				Page 1										
Item ID: Revision ID:	D3874-1				Accept	*N900	040	100)*	Setup	Start	*N	S1*	- Cree -
Item Name:	Floor Prot	tector				3					Stop	*N	S2*	
Start Date: Required Date	5/08/13 : 5/31/13		ty: 1.00 Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Reference:				•						n .	Staut			
Approvals:	Process	Plan: ML	<u>.</u> 5	Date: B-05-15	Tooling:	D:	ate:			Run	Start	*N	R1*	
				Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operati Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp	
Draw Nbr		Revision Nbr			,									
D3874		Rev A												
100					0.00								DAR	
100 HandThermo			Memo		0.00				x2				(68	/_
Hand Finishing The	ermoforming	,	1-Cut Sheet	to required Blank size									13/04/	0
													(
105					0.00								OAG,	A
105		Dry Mater	ial						64				9 89 V	,
HandThermo			Memo		0.00				40				2/1/	,
Hand Finishing Th	ermoforming	<u>, </u>	Dry Sheet a	s per QSI022 POLYCARBO	ONATE								13/06/09	7

Temp: 240° F

Time IN: 7:00 pm 13/06/08

Time OUT: 6:00 am 18/06/04

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UPD	ATE		-	
									<u>-</u>		QA Closed:	Date	:
Work Orde	ar.			·		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	-
· VVOIR OIG	٠					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	۱o. ₋					Scrap		1	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCD A						Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
NCR N	NO									Composite	1	2uppliei [
Root		, .			Descri	iption of work order update Initial				on	Sign &	:	
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material												:	
Setup			<u> </u>										
Other													
Process													
Supplier 🥳							ļ						
Training							Į						
Unapproved													
						F,	AUL	T CATE	GORY				
Landi	ng G	Gear				General					•	_	 1
		Bending			. L	Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	<u> </u>	Inspecti	on Incomplete		Part Incorred	ct _	Weld
,		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		•
		Heat Trea	at			Countersink	Mislabeled			Positioned V	Vrong	_	
		Inspectio	spection Strip in Tube Cut Too Short					Misread	i .		Power Loss/	Surge	Other
	П	Ripples in	Bend					Öffset					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde <i>May-13-13 1:09:</i>		101596			*101	596*					•		Page 2
Revision ID:	D3874-1 Floor Pro	tector			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	*N: *N:	S1* S2*
	5/08/13 5/31/13	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item l Customer:	D:						· ·
Approvals:	Process QC:	Plan:	Date:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N' *N'	R1* R2*
Sequence ID/ Work Center ID 110 *110* Thermoform Thermoforming Mach		3-Thermot Dwg Rev: Folio Rev:	Tool to required form as per Dwg	and Folio #I	Set Up/ Run Hours 0.00 0.00 TA038 using tool DT94	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp O7 O7 13/06/94
*140 *140 *HandThermo Hand Finishing There	moformin <u>ş</u>	Memo g 1-Trim to	finished dimens	ions as per D	0.00 0.00 wg				<u>v</u> 2				13/06/10
150 *150* QC		QC2- Inspect parts off Memo	machine FAI/FA	AIB	0.00				42				Dh,

Quality Control

Complete FAI document

NCR:	Yes	/	No

NCR:	Yes	/ No				WORK ORDER NON-	-COI	NFORI	MANCE / UP	DATE		DQA:	Date	e:
·									-			QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part f						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		l	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	iption of work order update Initial Action						Sign &		
Cause		Date	Step	Qty		or Non-conformance	- 1	nief Eng		ription		Date	Verification	QC Inspector
oc/Data										!				
quip/Tooling Operator Material etup														
other rocess														
upplier raining Inapproved														
парргочец	<u> </u>		<u>i</u>	11			FAUI	LT CATE	I GORY				<u> </u>	-
Landi	ng (Gear				General								
. •		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection	Crimped it n Strip in)/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	ion Incomplete ions Incomplete/ enance eled	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	\vdash	Ripples in			<u> </u>	Drill Holes	\vdash	Offset	7 - 116 41 -					
	<u> </u>	Torque W			\ 	Drawing	-		Calibration					
	_	Turning S Wave/Tw			<u> </u>	Finish Folio	\vdash	1	Sequence Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

170

Identify as per dwg & Stock Location:

0.00

170 Packaging

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

Quality Control

0.00

Page 3

Insp.

OC Quality Control

160

Memo

Memo

0.00

											DQA:	Date:	
NCR: Ye	es /	No				WORK ORDER NON-C	COI	NFORI	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Order	÷.			-		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No						Rework Scrap Use-as-is			Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	o					Work Order Update	_	THE	Large Fab	Composite	l nee, stor	Supplier	
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								ڏن.					
						F	AUI	T CATE	GORY				
Landin	g Gea	ır			,	General	_	7			ר		1
		ending			$oxedsymbol{oxed}$	Bend	\vdash	Grain			Ovalized		Pressure/Forced
1	Ce	ntre No	t Concei	ntric to	o/s	BOM/Route	1	Hardwa	re		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

May-13-13 1:09:33 PM

Work Order ID:

101596

Parent Item:

D3874-1

Parent Item Name:

Floor Protector

Start Date: 5/08/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 09.02.06 New Issue DL Material 10/04/21 DI

IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	489.1100	4.38	4.38			Wh.
				Location		Loc Oty	<u>Lo</u>	c Code					13/06/1
				therm	1127	489.11 489.11			8	1.76 sq	H.		٠ /

NCR:	Yes		No
IICII.	163	,	110

Date:

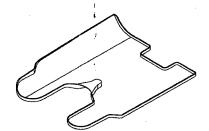
NCR: Y	es / No				WORK ORDER NON-	CON	IFORN	MANCE / UP[DATE			
								_		QA Closed:	Date:	
Work Orde	r:	,			DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework	7 I		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	o				Scrap]	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCŖ N	o				Work Order Update]		Large Fab	Composite		Supplier	
	_	_	, ,									
Root					ption of work order update		nitial	Act		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chi	ef Eng	Descr	iption -	Date	Verification	QC Inspector
oc/Data	4											
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etup	-											:
Other												
rocess	\dashv				•	1						
upplier									•			
raining Inapproved	┪,	,						·				
mapproved	<u> </u>	1	<u> </u>			ΑΠΙ	T CATE	GORY				
Landin	g Gear				General						· · · · · · · · · · · · · · · · · · ·	
	Bending			. [Bend		Grain		1	Ovalized		Pressure/Forced
	→	ot Conce	ntric to	o/s	BOM/Route	П	Hardwa	re		Over/Under	tolerance	Temperature/Cure
Ī	Cracks				Broken/Damaged	П	Inspecti	on Incomplete	•	Part Incorred	c t	Weld
<u> </u>	Crushed	/Crimped			Burrs	П	Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	issing	Wrong Stock Pulled
Ī	Cuffs	·	,	,	Contamination	П	Mainte	enance		Part Moved		· .
	Heat Tre	at			Countersink	П	Mislabe	eled	. [Positioned V	Vrong	_
1	Inspection	n Strip in	Tube		Cut Too Short		Misread	d .		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset		_			
Ī	Torque \	Vaves in I	Extrusio	n 🗌	Drawing		Out of 0	Calibration		:		
	Turning	Sequence			Finish		Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

DART AEROSPA	ACE LTD		T.	Wo	rk Order:	101596
Description: Floor	Protector			<u>Pa</u>	rt Number:	D3874-1
Inspection Dwg: D	3874 Rev: A					Page 1 of 1
		RTICLE INSF First Article		CHECK Prototy		
	T	HERMOFORM	ING SE	CTION		
Description .			Accept	Reject	Method of Inspection	Comments
Inside Radii less tha	an <u>3/4</u> "					
Shape Definition						
Texture Retention Material imperfectio scratching	ns such as bumps,	cracks, voids,				
Measured by:	dh.				Date:	13/06/04
		TOIRARAISIC	CEPTIC			
Drawing		TRIMMING	SECTIO	N	Seeth and as	·
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
_	Tolerance Min	Actual Dimension				Comments
Dimension		Actual Dimension 0.1004 0.085				Comments
Dimension 0.050	Min	Actual Dimension				Comments
0.050 0.065	Min Min	Actual Dimension 0.1004 0.085			Inspection II II C	Comments
Dimension 0.050 0.065	Min Min	Actual Dimension 0.1004 0.085			Inspection II II C	Comments
Dimension 0.050 0.065	Min Min	Actual Dimension 0.1004 0.085			Inspection II II C	Comments
Dimension 0.050 0.065	Min Min Min	Actual Dimension 0.1004 0.085			Inspection II II C	eu.
0.050 0.065 0.5	Min Min Min	Actual Dimension 0.1004 0.083° 0.587°			Inspection THE COP TO THE PORT OF THE PO	eu.
0.050 0.065 0.5	Min Min Min Min Y: 16 17/04	Actual Dimension 0.1004 0.083° 0.587°			Inspection THE COP IN PROPERTY IN THE COP I	eu.
Dimension 0.050 0.065 0.5 Measured b Audited b	Min Min Min Min Y: 16 17/04	Actual Dimension 0.1004 0.083° 0.587°			Inspection TH-DT C PL-O2 V Date:	13/04/10 N/A



101596MC5 13-0515

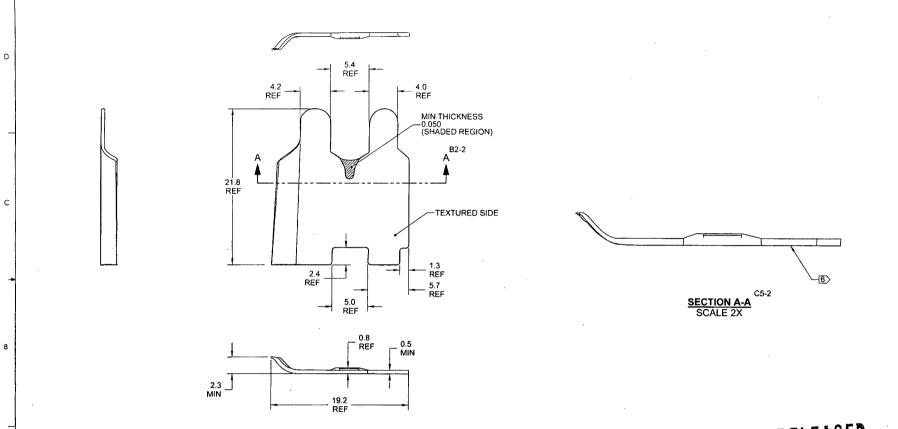
'P7

D3874-1 FLOOR PROTECTOR

D3874-2 FLOOR PROTECTOR

Α	NEWISS	UE		PH	09.01.29
REV.			DESCRIPTION	BY	DATE
DESIGN	1	PH	DART AEROSPA	CE L	ſD
DRAW	1	PH	HAWKESBURY, ONTARIO		-
CHECK	ED	b .	DRAWING NO.		REV. A
MFG. A	PPR.	_ \$7.0	D3874		SHEET 1 OF 3
APPRO	VED	/11/	TITLE		SCALE
DE APP	R.	-21	FLOOR PROTECTOR		NTS
DATE	09.0	1.29	COPYRIGHT © 2009 BY DARY AE THIS DOCUMENT IS PRINTED AND CONFIDENTIAL AND IS SUPPLED ON NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMENCATE	THE EXPRESS	CONDITION THAT IT IS

101596



D3874-1 FLOOR PROTECTOR

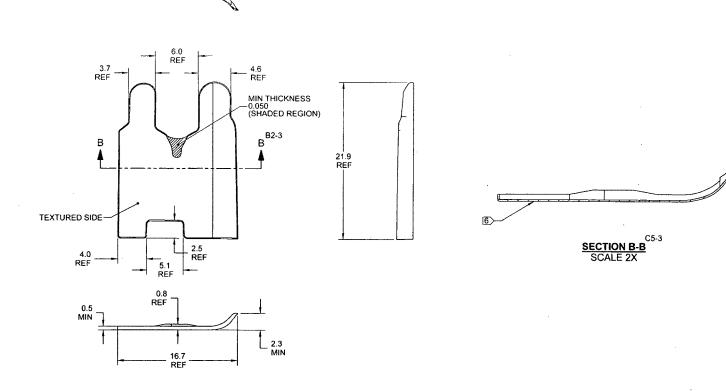
NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR
(MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYI
7) WEIGHT: 1.5 lbs

7) WEIGHT: 1.5 lbs 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. D3874 CHECKED REV. A MFG. APPR. SHEET 2 OF 3 TITLE APPROVED SCALE FLOOR PROTECTOR

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D3874-2 FLOOR PROTECTOR

5

NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS 118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
7) WEIGHT: 1.5 Ibs
8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3874 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE FLOOR PROTECTOR DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD DATE 09.01.29

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